

Duplicate. Split - 1

Work Order ID 81715 - 2

81715

Page 1

Wednesday, March 21, 2012 10:11:07 AM

Item ID: D4212-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 429 Clamp Cushion

Start Date: 3/29/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/29/2012 Req'd Qty: 10.00

10

Customer:

Reference:

12-03-21

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4212

C

100

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Turn as per folio FA974 & dwg

FOLIO REV: N/ADWG REV: C

2-Deburr as required

16 4 0 12/03/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

16 4 0 12/03/22

Work Order ID 81715***81715***

Page 2

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Item ID: D4212-1

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N900040100Setup Start ***NS1***

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Item Name: 429 Clamp Cushion

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

amf 12/03/23

120

QC

Memo

0.00

Quality Control

16

130 Identify as per dwg & Stock Location. ST 451 0.00

130

Packaging

Memo

0.00

Packaging

(16x) SP-12-03-23

140 QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/3/26

MF
12-03
26

Picklist Print

Page 1

Wednesday, March 21, 2012 10:11:06 AM

Work Order ID: 81715

Parent Item: D4212-1

Parent Item Name: 429 Clamp Cushion

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-09-29 JLM VERIFIED BY:DD
DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1 UHMW U-Channel		Manufactured	No			100	f	1.0000	0.3708	3.9031579			

Location

Loc Qty

Loc Code

MAT055

1

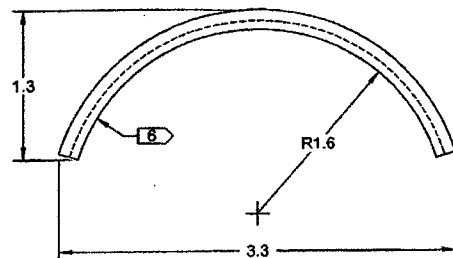
63828

1

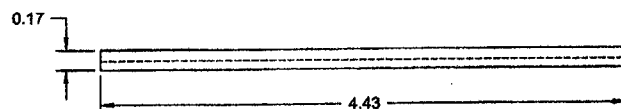
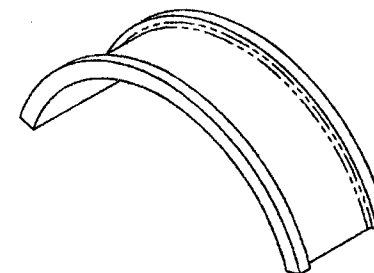
81713

7.917

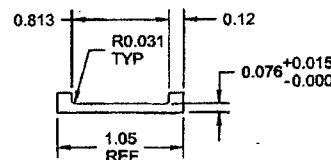
12/03/22



D4212-1 CLAMP CUSHION
(MAKE FROM D4212-1F)



D4212-1F FLAT MACHINED STATE



RELEASED
2010-12-23

NOTES:

- 1) MATERIAL: MAKE FROM D4287-1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4212-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

REV.	DESCRIPTION	BY	DATE
C	ADDED FLAT MACHINED STATE- CHANGED DIMENSIONS IAW MANUFACTURING PROCESS. REF: PAR10-29.	MB	10.12.07
B	REDESIGN TO REDUCE COST. "CLAMP CUSHION" WAS "428 CLAMP CUSHION". MATL WAS MUHMMWTR3.500W.X00XW (ZN A7-1)	MB	10.10.28
A	NEW ISSUE	MB	10.09.28
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4212 TITLE CLAMP CUSHION COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN			
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	10.12.07		